Monday, 10/30/2006 4:15:07 PM Date: Kim Johnston User: **Process Sheet** : LUG BRACKET **Drawing Name** : CU-DAR001 Dart Helicopters Services -Customer : 29228B Job Number : 10339 **Estimate Number** :414: : D2658 Part Number P.O. Number S.O. No. : ぬいへ . D2658 REV D : 10/30/2006 **Drawing Number** This Issue : N/A Project Number Prsht Rev. NIA : PURCHASED PARTS **Drawing Revision** Type First Issue : 28857B Material **Previous Run** : 11/25/2006 Each Qty: 30 Um: **Due Date** Written By Checked & Approved By 05-11-07 JLM : Est Rev:A Comment Now on Waterjet 06-08-23 JLM Est Rev:B Additional Product Job Number: Description: **Machine Or Operation:** Seq. #: 1010/1025/A21/6aA SHEET 1.0 M1010S12GA Total: 3.5910 sf(s) Comment: Qty.: 0.1197 sf(s)/Unit 1010/1025/A21/6aA SHEET 12 GAUGE .100" THK WATER JET FLOW WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg D2858 Dwg Rev: Prog Rev:_ SADOS: 10:04 F. . 8111120 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 111104 30 SECOND CHECK QC8 4.0 Comment: SECOND CHECK 30 BRAKE NC NC BRAKE Comment: NC BRAKE 30 06:11:13 SAD 1-Deburr as required. 2-Bend on CNC brake using DT8254Identify as D2658

Dart A	rospace Ltd							* ·	
W/O:			WORK ORDER	CHANGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:	Fault Category:	NCR	2: Yes	(No) DQ	<u> </u> A:) Date: ℰ	112/08
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NCR:			WORK ORDER NON-COM	NF PRMANCE	(NC	R)			
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	Description of NC	Corrective Action		Section B		Varification		
STEP	Section A	Initial Chief Eng	Action Descri	otion	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section A Initial Action Descri	STEP Description of NC Corrective Action Section B Section A Corrective Action Section B	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Portion Description Sign & Section C Chief Eng

NOTE: Date & initial all entries

Monday, 10/30/2006 4:15:08 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: LUG BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 29228B Part Number: D2658 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 PACKAGING 1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_ FINAL INSPECTION/W/O RELEASE 8.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion C LOG 12108

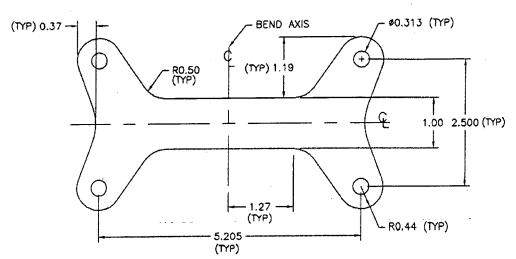
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DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descr Chief Eng Chief Eng		Section B ption	Sign &			Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

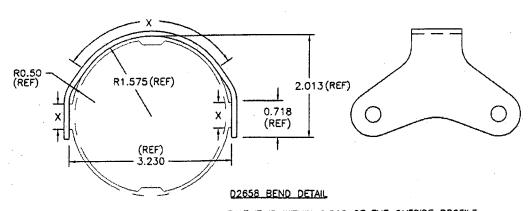


	DESIG	#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
١	CHEC	(ED	APPROYED	DRAWING NO. REV. D
ı	(K –	KE	D2658 SHEET 1 OF 1
١	DATE			TITLE SCALE
ı	98.	12.14		LUG BRACKET 5:9
	Α	,	97.11.03	NEW ISSUE
	В		97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE
-	С		98.10.23	UPDATE MATERIAL (TSR A1114)
	D		98.12.14	REMOVE TOOLING HOLE (TSR A1040)

RELEASED 98.12.14 ps



D2658 FLAT PATTERN SYMMETRICAL ABOUT BOTH CENTRE-LINES (\mathcal{C})



D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

SHOP COPY RETURN TO

ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 CAUCE) NGINEERING MIN. ULTIMATE TENSILE STRENGTH # 42 ksi UNCONTROLLED MIN. YIELD TENSILE STRENGTH = 28 ksi UNCONTROLLED COPY MATERIAL:

SUBJECT TO AMENDMENT

WITHOUT NOTICE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSIONS ARE IN INCHES

WORK ORDER NO. 29228B

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DART AEROSPACE LTD		Work Order:	2928818
	*	Part Number:	52158
Description:		Par Moniber.	102.676
Inspection Dwg: Rev:			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Actual

X

Prototype

Method of

Drawing Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
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